

Date: Tuesday, 8/7/2007 5:33:30 PM  
 User: Jean-Luc Menard

## Process Sheet

|                       |                                     |  |                  |                             |  |
|-----------------------|-------------------------------------|--|------------------|-----------------------------|--|
| Customer              | CU-DAR001 Dart Helicopters Services |  | Drawing Name     | : PANEL                     |  |
| Job Number            | : 33838                             |  |                  |                             |  |
| Estimate Number       | : 10765                             |  |                  |                             |  |
| P.O. Number           | : N/A                               |  | Part Number      | : D32451                    |  |
| This Issue            | : 8/7/2007 S.O. No. : N/A           |  | Drawing Number   | : D3245 REV A               |  |
| Prsht Rev.            | : NC                                |  | Project Number   | : N/A                       |  |
| First Issue           | : N/A                               |  | Drawing Revision | : A                         |  |
| Previous Run          | : 23889                             |  | Material         | : N/A                       |  |
| Written By            | <u>JL/07-08-07</u>                  |  | Due Date         | : 8/14/2007 Qty: 1 Um: Each |  |
| Checked & Approved By |                                     |  |                  |                             |  |
| Comment               | : Est. A 04.07.07 New issue KJ/JLM  |  |                  |                             |  |

## Additional Product

|  |   |   |
|--|---|---|
| Job Number:  |    |   |
| Seq. #:  | Machine Or Operation:   | Description :   |
| 1.0  | M304S22GA   | 304/316 .032 Sheet  |
|  |    |    |
| Comment: Qty.: 0.8442 sf(s)/Unit Total : 0.8442 sf(s)<br>304/316 .032 Sheet<br>Batch: M105061 <span style="float: right;">SAD 07/08/07</span>  |   |   |
| 2.0  | WATER JET   | FLOW WATER JET  |
|  |  |  |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D3245 ****prog.D3245-1/2**** <span style="float: right;">(No Holes)</span><br>Dwg Rev: <u>A</u><br>Prog Rev: <u>A</u><br>2-Deburr if necessary <span style="float: right;">SAD 07/08/07 ①</span> |   |   |
| 3.0  | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE  |
|  |  |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/08/07 ①</span>  |   |   |
| 4.0  | QC8   | SECOND CHECK  |
|  |  |  |
| Comment: SECOND CHECK <span style="float: right;">SAD 07/08/07 ①</span>  |   |   |
| 5.0  | BRAKE NC  | NC BRAKE  |
|  |  |  |
| Comment: NC BRAKE<br>Deburr if necessary<br>C'sink as per Dwg D3245 <u>mf</u> 07-08-09.<br>Form D3245-1 as per Dwg D3245 identify as D3245-1 <span style="float: right;">SAD 07/08/08 ①</span>   |   |   |

Date: Tuesday, 8/7/2007 5:33:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 33838

Part Number: D32451

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Fr 07/08/09 + 1041

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

JL 07-08-10

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 07/08/10

Job Completion



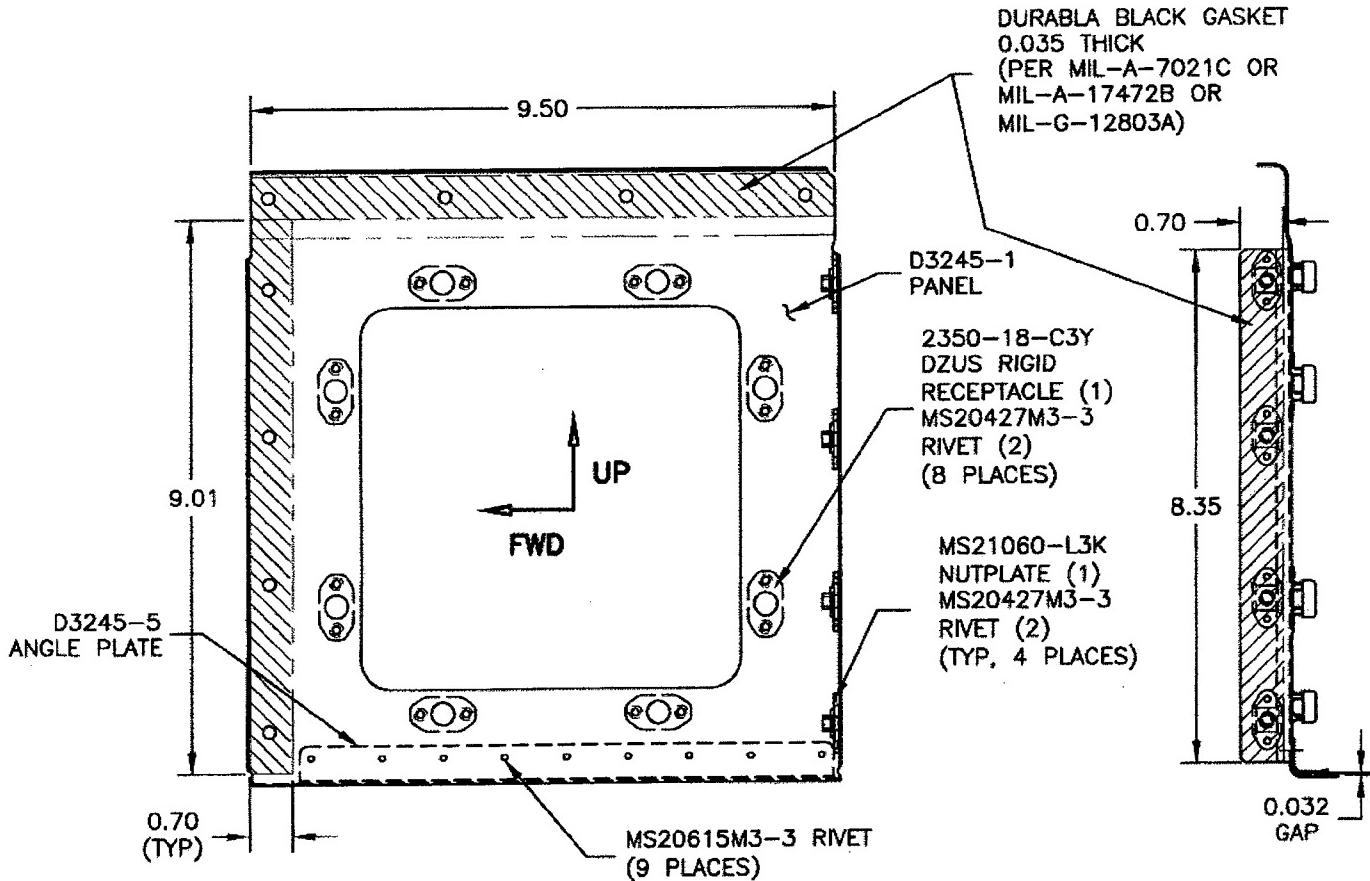
JL 07-08-10



COPY ISSUED  
6

|                     |                       |   |                        |
|---------------------|-----------------------|---|------------------------|
| DESIGN<br>RF        | DRAWN BY<br><i>IP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>H</i> | APPROVED<br><i>H</i>  | DRAWING NO.<br>D3245                              | REV. A<br>SHEET 1 OF 6 |
| DATE<br>04.01.27    |                       | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:3           |
| A                   | 04.01.27              | NEW ISSUE   |                        |

RELEASED  
04.04.21 *H*



### D3245-041 ACCESS PANEL ASSEMBLY

#### D3245-041 NOTES:

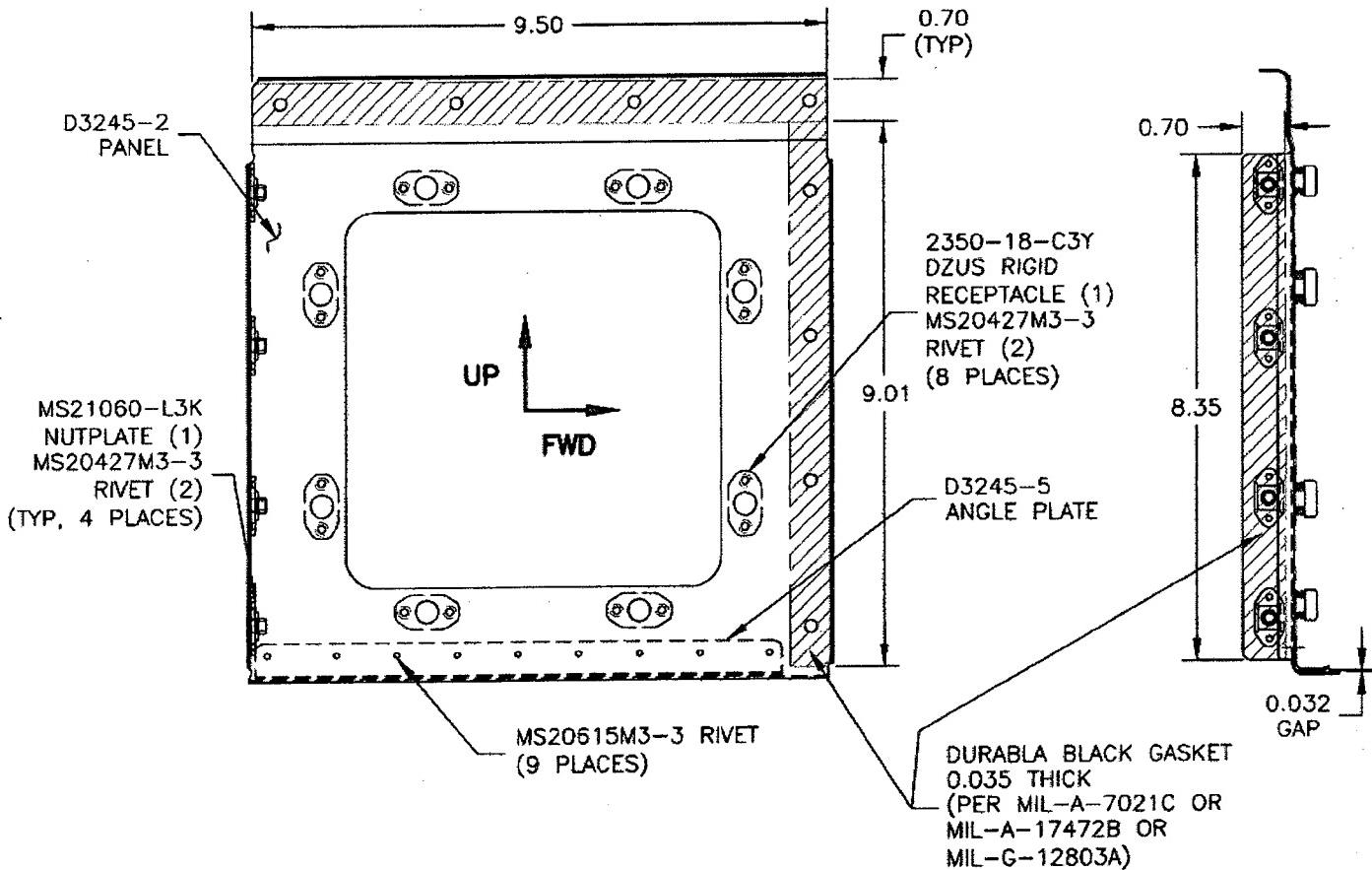
- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



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|                     |                       |   |                        |
|---------------------|-----------------------|---|------------------------|
| DESIGN<br>RF        | DRAWN BY<br><i>JP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>#</i> | APPROVED<br><i>#</i>  | DRAWING NO.<br>D3245                              | REV. A<br>SHEET 2 OF 6 |
| DATE<br>04.01.27    |                       | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:3           |

RELEASED  
04.01.27 *[Signature]*



### D3245-042 ACCESS PANEL ASSEMBLY

#### D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE  
IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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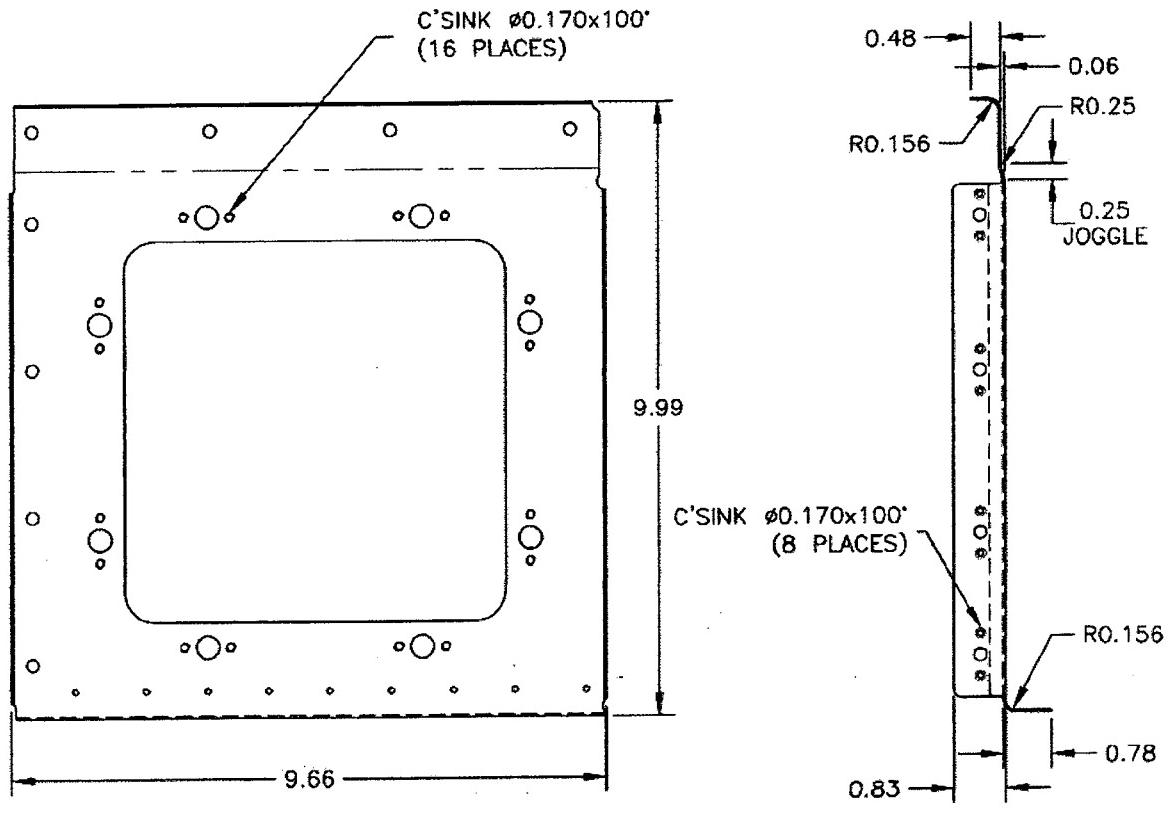


COPY IS  
1 OF 1

|                         |                       |  |
|-------------------------|-----------------------|--|
| DESIGN<br><b>RF</b>     | DRAWN BY<br><i>AP</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>ff</i>    | APPROVED<br><i>ff</i> | DRAWING NO.<br><b>D3245</b>                              |
| DATE<br><b>04.01.27</b> |                       | TITLE<br><b>ACCESS PANEL ASSEMBLY</b>                    |

REV. A  
SHEET 3 OF 6  
SCALE  
1:3

RELEASED  
04.04.21 *ff*



**D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE**

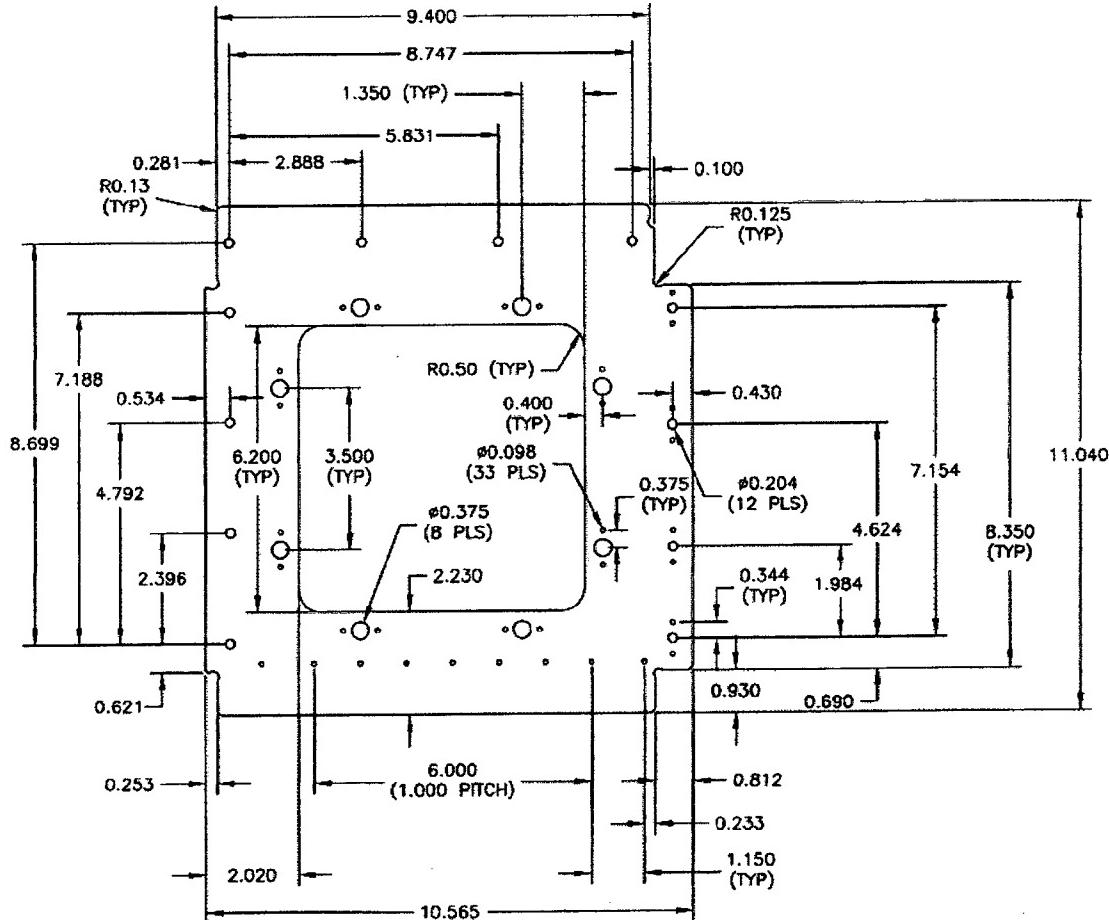
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|                     |                                |   |              |              |
|---------------------|--------------------------------|---|--------------|--------------|
| DESIGN<br>RF        | DRAWN BY<br><i>GP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |              |
| CHECKED<br><i>#</i> | APPROVED<br><i>#</i>           | DRAWING NO.<br>D3245                              | REV. A       | SHEET 4 OF 6 |
| DATE<br>04.01.27    | TITLE<br>ACCESS PANEL ASSEMBLY |   | SCALE<br>1:4 |              |

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04.04.21



**D3245-1/-2 PANEL FLAT PATTERN**

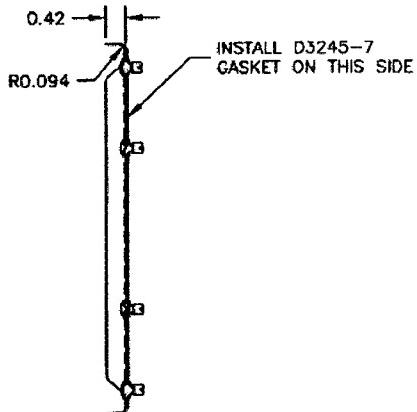
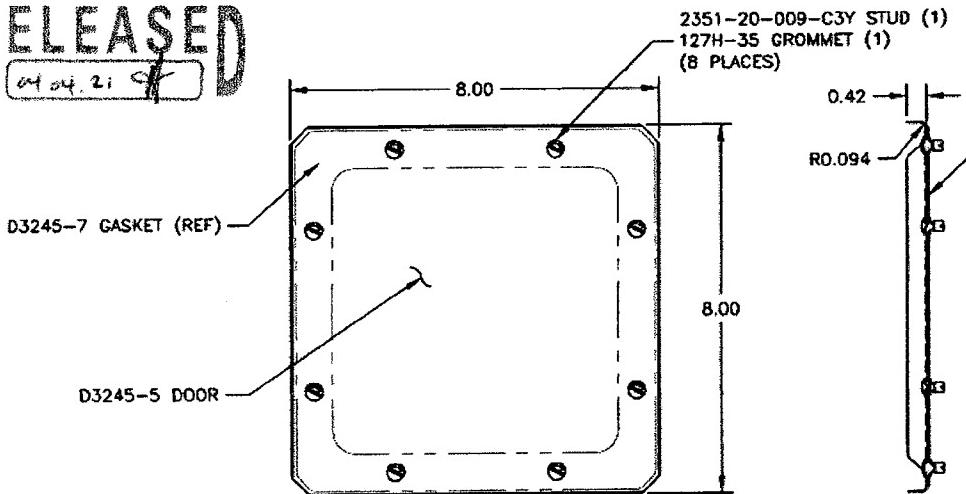
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
  - 2) ALL DIMESIONS ARE IN INCHES
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

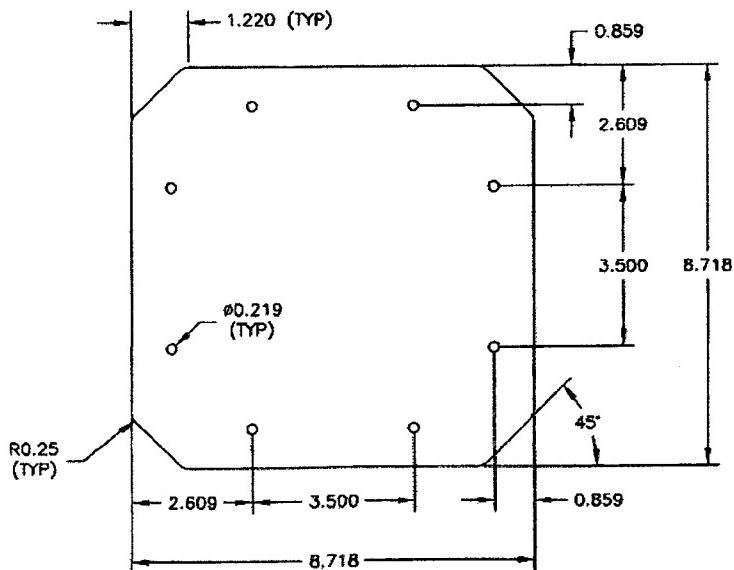


|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br><i>GP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3245                              | REV. A<br>SHEET 5 OF 6 |
| DATE<br>04.01.27              |                                | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

**RELEASED**  
04.04.21 *[Signature]*

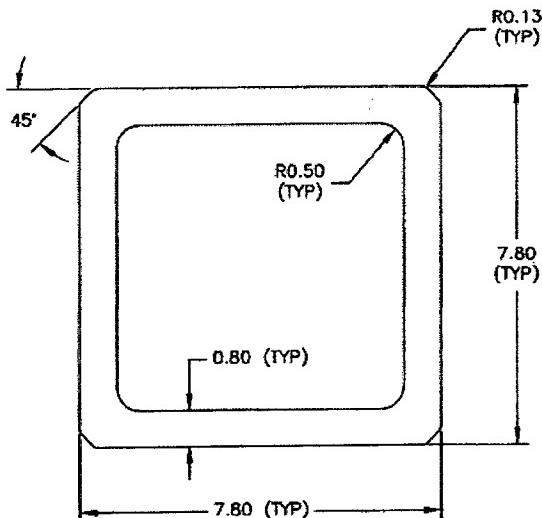


**D3245-043 DOOR ASSEMBLY**



**D3245-3 DOOR FLAT PATTERN**

MATERIAL: AISI 304/316 SS 0.032 THICK  
ANNEALED (REF. M304S22GA)



**D3245-7 GASKET**

MATERIAL: DURABLA BLACK GASKET 0.035 THICK  
(PER. MIL-A-7021C OR MIL-A-17472B  
OR MIL-G-12803A)

**D3245-043 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE  
IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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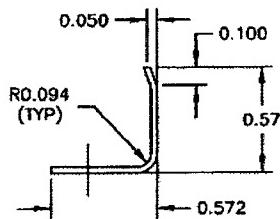
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REF ID: A

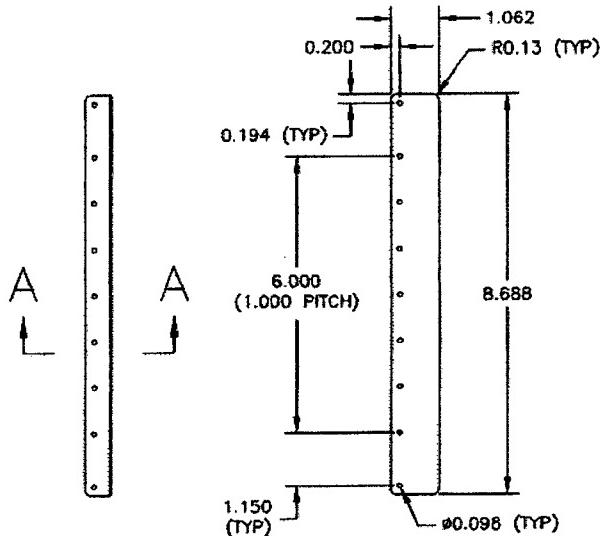
|          |                       |   |              |
|----------|-----------------------|---|--------------|
| DESIGN   | DRAWN BY              | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED  | APPROVED              | DRAWING NO.                                       | REV. A       |
|          |                       | D3245   | SHEET 6 OF 6 |
| DATE     | TITLE                 | SCALE   |              |
| 04.01.27 | ACCESS PANEL ASSEMBLY | 1:4   |              |

RELEASED  
04-04-05 #



D3245-5 BEND DETAIL

VIEW A-A  
SCALE 1:1



D3245-5 FLAT PATTERN

D3245-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

|                              |              |             |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD           | Work Order:  | 33839       |
| Description: Panel           | Part Number: | D37452      |
| Inspection Dwg: D3245 Rev: A |              | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |          |             |              |                     |            |
|--------------|----------|-------------|--------------|---------------------|------------|
| Measured by: | SAD      | Audited by: | <i>J. H.</i> | Prototype Approval: | <i>N/a</i> |
| Date:        | 07/08/08 | Date:       | 07.08.08     | Date:               |            |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

|                    |              |             |
|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order:  |             |
| Description:       | Part Number: |             |
| Inspection Dwg:    | Rev:         | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |             |                     |
|--------------|-------------|---------------------|
| Measured by: | Audited by: | Prototype Approval: |
| Date:        | Date:       | Date:               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

| W/O:     |      | WORK ORDER CHANGES  |                            |  |    |          |     |                                     |                          |
|----------|------|---|----------------------------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE  |                            |  | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 07/08/09 | 6.1  | 8 2350 - 18C 3C Batch <u>m19688</u><br>16 MS 20427 M3-3 Batch <u>m101840</u><br>9 MS 20615 M3-3 Batch <u>m17654</u><br>1 D 3245-5 Batch <u>B33837</u> |                            |  | MF | 07-08-09 | 1   |                                     | JM 07-09-09              |
|          |      | Durable Block<br>1 .70 x 8.35<br>1 .70 x 9.50<br>1 .70 x 9.01   | Gasket Batch <u>B23711</u> |  |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |  |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |  |
|      |      |                                  |                             |                                 |                |                           |                       |                          |  |
|      |      |                                  |                             |                                 |                |                           |                       |                          |  |
|      |      |                                  |                             |                                 |                |                           |                       |                          |  |

NOTE: Date & initial all entries